

Work Order ID 52774

October 14, 2009 9:55:03 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

09-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: *M109213* 0.00
Large Fab



Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 ✓
2-Cut (4) D2236 From D3166-3 ✓
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 ✓
4-Weld as per Dwg D2512 using Welding Jig DT 9436 ✓
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041 ✓

SH 09/10/20

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

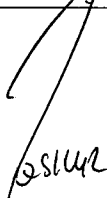




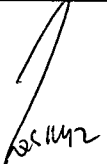




Quality Control

SH 09/10/20

Pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2512 PAR #: N/A Fault Category: Large Feb NCR: Yes No DQA: N Date: 09-11-06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 09-11-18

NCR: 52774		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/23	A 100	During weldin inspection Found D2012-117 welded on. Basket is NOT A "130" Def. welder was confused between		- cut of D2012-117 AND Scrap. - Build welding marks - Dwg + w/d is clearly	 09/10/26	 09/10/26		 09/10/23
		Parts list AND Dwg. R.C: LCA, should ask. should Ask		Marked for to weld D2012-117 if for A 130 Basket	 09/10/26	 09/10/26		 09/10/23

NOTE: Date & initial all entries

Work Order ID 52774

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Required Date: 28/10/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

278 09/10/27

40

q



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

PRESSURE WASH

BR 09-10-27

1

Ø

Powdercoat

Memo

M112260

0.00

27 09/10/27

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME:

11:45am

OVEN TEMPERATURE:

400°F

FINISH TIME:

12:15pm

2ND COAT:

START TIME:

12:45

OVEN TEMPERATURE:

400°F

FINISH TIME:

1:15pm

Work Order ID 52774

October 14, 2009 9:55:03 AM



Page 4

Item ID: D2512

Accept



Setup Start



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Stop



Item Name: Basket Lid 205/350

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/29 HJ

Bl 09-10-28

Picklist Print

October 14, 2009 9:55:11 AM

Page 1

Work Order ID: 52774



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	30.0000	2.0000			
Clevis												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

30

31101

2

52498

28

2x

09/10/19

ONLY APPLICABLE ON D130-701-117

D2232-1RevC

Manufactured

No

100

Each

30.0000

2.0000



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

28

50896

8

51105

20

2x

09/10/19

Picklist Print

Page 2

October 14, 2009 9:55:11 AM

Work Order ID: 52774



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	20.0000	2.0000			
Spacer Bushing												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

20

51331

20

D2506RevF

Manufactured No

100

Each

6.0000

1.0000



Label Plate

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

2

44275

1

51135

1

Main Warehouse

WA

4

51303

4

2x *SY* 09/10/19

1x *SY* 09/10/19

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Shop Packet Print

Page 2

Picklist Print

Page 3

October 14, 2009 9:55:11 AM

Work Order ID: 52774



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	76.0000	2.0000			
Mounting Bracket												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46086

2

48428

1

51120

10

Main Warehouse

WA

63

50872

14

51745

49

2x 14/09/10/19

D3166-3RevA1

Manufactured

No

100

Each

13.6210

1.0000



Basket Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

13.621

50033

0.0527

50618

1.5683

51249

6

52058

6

1x 14/09/10/16

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Shop Packet Print

Page 3

Picklist Print

October 14, 2009 9:55:11 AM

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Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	306.0011	18.9474			
Expanded Metal Flat SS												

SAD 09-10-16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

306.0011065

110134

6.7

110629

14.41

111630

9.15

111956

0.000017

112147

54.8205895

112311

28.9205

112707

192

18,9474

M304TS0.750W.065

Purchased

No

100

f

678.9022

45.8741



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

678.9022

112398

678.9022

END BAR SCRAP

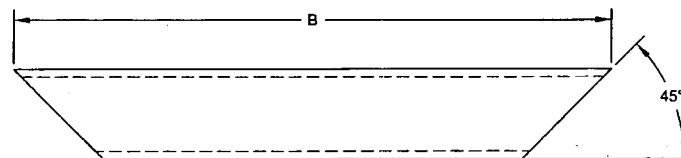
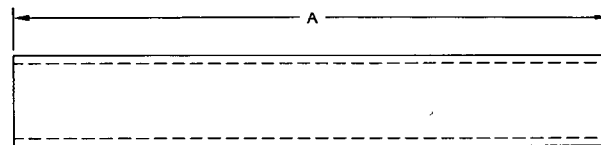
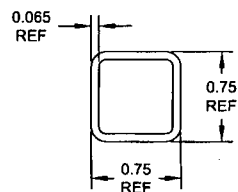
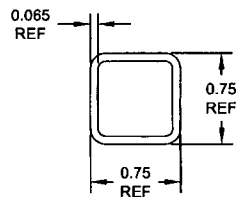
45.8741 14 09/10/19
1 feet

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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WORK ORDER
NO. 52774
BT 09-10-14

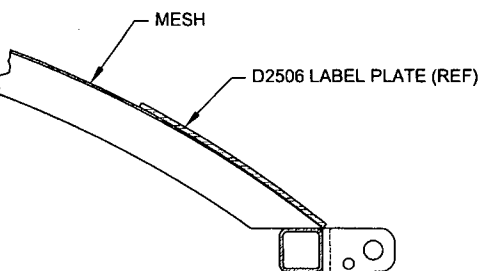
RELEASED
08-08-21/118



D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

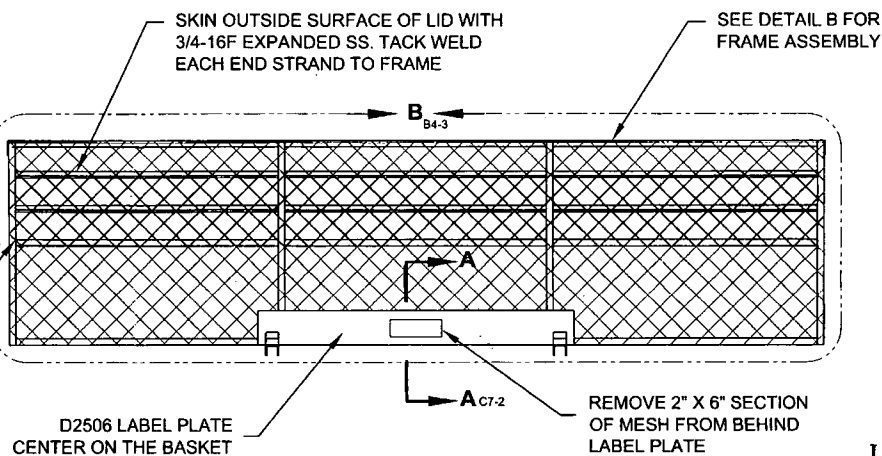
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. REV. E D2512 SHEET 1 OF 4 TITLE SCALE BASKET LID ASSEMBLY (350/212) NTS	
DATE	08.06.17	<small>COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

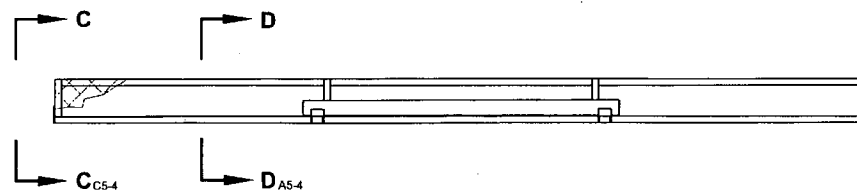
FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

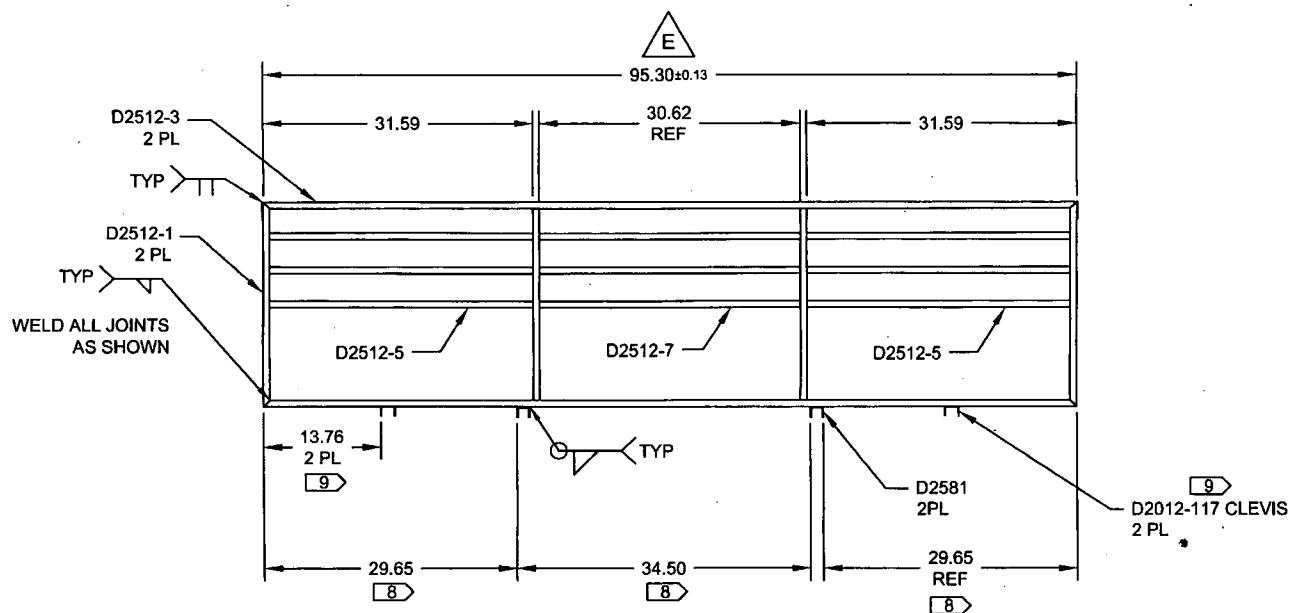
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



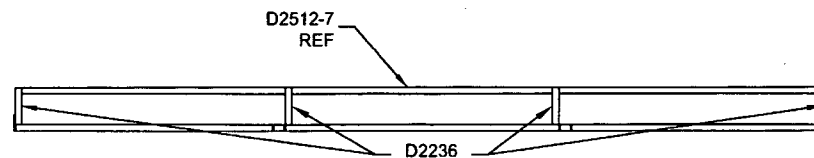
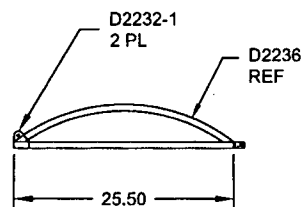
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WORK ORDER
NO. 52774

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DETAIL B _{C3-2}
FRAMEWORK ONLY SHOWN FOR CLARITY



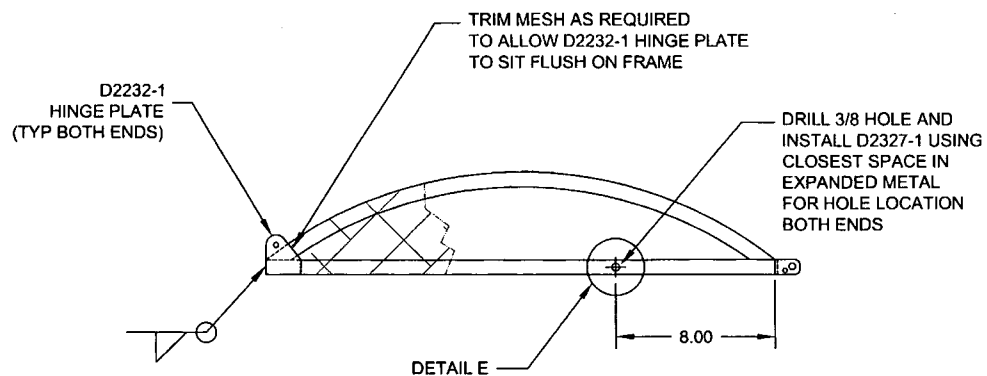
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NO. 52774

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08.06.17

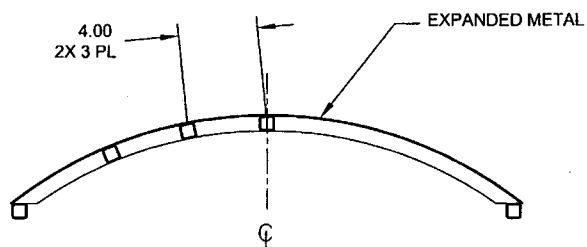
- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
 - 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO. D2512	REV. E SHEET 3 OF 4
MFG. APPR.	10	TITLE	SCALE
APPROVED	10	BASKET LID ASSEMBLY (350/212)	NTS
DE APPR.	10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.06.17		

8 7 6 5 4 3 2 1

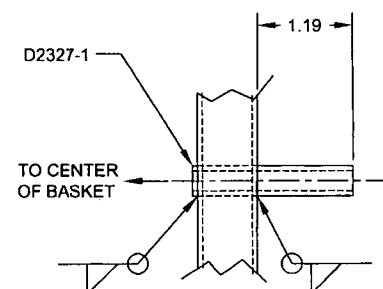


VIEW C-C SIMILAR BOTH END RIBS A5-2







SECTION D-D SAME BOTH CENTER RIBS A4-2

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WORK ORDER
NO. 52774



DETAIL E C6-4

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1